



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1701

Job Sheet 190841



Part No: 647.1701

Job Qty: 4 pcs

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/19

Job Tracking No: *order 13713*

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS IPP REV:B 18.03.01 REVISE BOM AS PER
DWG DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs	3/8/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		DAS
							Packaging 1 - 9		36
							Packaging 1 - 10		9-89
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Plex 2/19/19 7:25 AM Dart.lajeunesse.marie

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Small Fab - 2 - B4B	4 pcs	3/8/19	0.00 1.64	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DAS
					Small Fab - 5 - B4B	36
					Small Fab - 6 - B4B	9-89
					Small Fab - 7 - B4B	
130	QC 5	4 pcs	3/8/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
190	Small Fab - 3 - B4B	4 pcs	3/8/19	0.00 1.64	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DAS
					Small Fab - 5 - B4B	36
					Small Fab - 6 - B4B	9-89
					Small Fab - 7 - B4B	
200	QC 5	4 pcs	3/8/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
210	Packaging 3-1 - Stock - B4B	4 pcs	3/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	

Plex 2/19/19 7:25 AM Dart.lajeunesse.marie

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	CC033 91 APR 04 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	4 pcs	3/8/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 APR 04 2019
					QC 21 - SA - 53	9-39

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine 6- Re-assemble as per dwg *** **TOUCH UP RIVET WITH PRIMER *** PRIMER BATCH: _____ ***

130 - (QC5- Inspect part completeness to step on W/O)

190 - (Small Fab) ASSEMBLE AS PER DWG

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1712	Gusset	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5104213
647.1713	Spacer	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5109415
CR3213-4-4	Rivet, Cherry	88 Ea (22 ea)	110-Packaging 1 - Pick Kit	5151577
MS21042-3	Nut use MS21042L3 per QSI 017	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5144852
MS27039-1-14	Screw	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5120449-40
NAS1149F0332P	Washer	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	5157648
647.1710	Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5157384
647.1711	Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5157926

008986

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	647.1710	4	12	0
	647.1711	4	7	0
	647.1712	4	19	0
	647.1713	4	21	0
	CR3213-4-4	88	174	0
	MS21042-3	4	206	0
	MS27039-1-14	4	48	0
	NAS1149F0332P	8	2,640	0
Part Specifications				
Specifications could not be found.				

Plex 2/19/19 7:25 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Container No: S168190

Part: 647-1701

Job No: 190841

Serial No/Batch: S168190

Revision:
Inspector:
Exp Date:
Instructions:

Date: 04/01/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hemel Hempstead, HX 8 5JH
UK
Tel: +44 (0)1462 432121
Fax: +44 (0)1462 432122
Email: sales@dartaero.com
www.dartaerospace.com